

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-020564**Date Inspected:** 10-Feb-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Qiu Wen.**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG components.**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Mr. Shailesh Wadkar was present during the times noted above for observations relative to the fabrication of the Self Anchored Suspension (SAS)

Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island, in Shanghai, China. QA Inspector observed and/or found the following:

Bay 14:

This QA Inspector observed the following work in progress:

OBG Seg 13AW:

Repair welding of weld joint no: SEG3013AA-063 [Edge Beam (EB) 3020D to Floor Beam (FB) 3193A, complete joint penetration (CJP) weld at Panel Point (PP) 119+1500]. The welder is identified as 066261 and was observed welding in the 3G position. Welding process was identified as Shielded Metal Arc Welding (SMAW). ZPMC Quality Control (QC) was identified as Zhang Ling. The welding variables recorded by this QC appeared to comply with welding procedure specification (WPS): 345-SMAW-3G(3F)-FCM-Repair. Repair welding was done as per Welding Repair Report (WRR): B-WR 20131 Rev-0.

Repair welding of weld joint no: SEG3013AA-052 (EB3020D to FB3189A, CJP weld at PP119). The welder is identified as 066261 and was observed welding in the 3G position. Welding process was identified as SMAW. ZPMC QC was identified as Zhang Ling. The welding variables recorded by this QC appeared to comply with

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WPS: 345-SMAW-3G(3F)-FCM-Repair. Repair welding was done as per WRR: B-WR 20131 Rev-0.

Repair welding of weld joint no: SEG3013K-123 (I-rib on EB3020B to FB3186A, CJP weld at PP119-1500). The welder is identified as 066361 and was observed welding in the 4G position. Welding process was identified as SMAW. ZPMC QC was identified as Zhang Ling. The welding variables recorded by this QC appeared to comply with WPS: 345-SMAW-4G(4F)-FCM-Repair. Repair welding was done as per WRR: B-WR 19912 Rev-0.

OBG Seg 13BW:

The Flux Cored Arc Welding (FCAW) process on weld joint no: Seg3014B-021 (Diaphragm to FB, CJP weld at PP122). The welder is identified as 201583 and was observed welding in the 2G position. ZPMC QC was identified as Zhang Ling. The welding variables recorded by QC appeared to comply with WPS: B-T-2232-ESAB.

The FCAW process on weld joint no: Seg3014D-350 (Diaphragm to FB, CJP weld at PP121.5). The welders are identified as 045227 and 067880 and were observed welding in the 2G position. ZPMC QC was identified as Zhang Ling. The welding variables recorded by QC appeared to comply with WPS: B-T-2232-ESAB.

OBG Seg 14W:

Repair welding of weld joint no: SEG3020AL-003 (FB3317 to SP, CJP weld at PP125). The welder is identified as 066421 and was observed welding in the 2G position. Welding process was identified as FCAW. ABF QA was identified as Wang Jiang Hua. The welding variables appeared to comply with WPS: 345-FCAW-2G(2F)-FCM-Repair-ESAB. Repair welding was done as per Critical Welding Repair Report (CWR): B-CWR 18585 Rev-0.

Notification no: 008325.

OBG Seg 14W:

This QA inspector performed Ultrasonic Testing (UT) of approximately 10% of the area previously tested and accepted by ZPMC QC personnel. This QA Inspector generated a UT report on this date. The members are identified as OBG components. The weld designations reviewed are as follows:

1) Seg3020K-026.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No significant conversations were reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang; phone: 15000422372., who represents the Office of Structural Materials for your project.

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Inspected By:	Wadkar,Sailesh	Quality Assurance Inspector
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Reviewed By:	Peterson,Art	QA Reviewer
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